

Date: Thursday, 5/4/2006 10:46:30 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 26975	Part Number	: D2574
Estimate Number	: 10534	Drawing Number	: D2574 REV E
P.O. Number	: <i>NA</i>	Project Number	: N/A
This Issue	: 5/4/2006 S.O. No. : <i>N/A</i>	Drawing Revision	: E
Prsht Rev.	: NC	Material	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Due Date	: 5/25/2006
Previous Run	: 26563	Qty:	12 Um: Each
Written By	: <i>See comment below</i>		
Checked & Approved By	: <i>06.05.04</i>		
Comment	: Est Rev: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: *B23946*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. *26975* Double check by: *J.L.*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

En 06/06/13

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

En 06/06/13

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En 06/06/13

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Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 06-06-13 (6)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.M 06-06-13 (6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

A.M 06-06-13 (6)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 6/6/14 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 480

P 6/6/14 (6)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ST 06/06/14 (6)

Job Completion



U 06-06-14

DART AEROSPACE LTD	Work Order: 26975
Description: Saddle, Aft Inboard	Part Number: D2574
Inspection Dwg: D2574 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	—	0.440	0.440	✓		
B	1.745	1.755		1.748	1.748	1.749	1.746		
C	3.495	3.505		3.498	3.498	3.501	3.498		
D	1.745	1.755		1.748	1.748	1.749	1.746		
E	7.990	8.010		7.998	8.002	8.002	8.003		
F	0.490	0.510		0.499	0.500	0.501	0.495		
G	0.257	0.262	DT8683		0.258	0.258	✓		
H	0.375	0.380	DT8684	—	0.376	0.376	✓		
I	0.490	0.510		0.501	0.498	0.499	0.498		
J	1.174	1.184		1.180	1.180	1.180	1.174		
K	0.558	0.578		0.567	0.568	0.568	0.563		
L	1.174	1.184		1.180	1.179	1.180	1.174		
M	1.365	1.375		1.370	1.371	1.372	1.367		
N	2.495	2.505		2.499	2.498	2.499	2.495		
O	4.119	4.129		4.123	4.121	4.121	4.123		
P	0.115	0.135		0.121	0.123	0.124	0.126		
Q	0.115	0.135		0.135	0.133	0.134	0.135		
R	0.240	0.260		0.248	0.247	0.245	0.251		
S	0.115	0.135		0.123	0.122	0.121	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.231	3.230	3.230		
V	0.230	0.250		0.237	0.238	0.237	0.238		
W	0.115	0.135		0.127	0.120	0.130	0.132		
X	0.307	0.312		0.312	0.309	0.310	0.310		
Y	0.760	0.765		0.760	0.761	0.761	0.763		
Z	0.352	0.372		0.372	0.368	0.368	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0.624	0.623	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.245	0.248		
AE	1.500	1.520		1.512	1.513	1.514	1.505		
AF	0.115	0.135		0.135	0.134	0.132	0.135		
AG	0.240	0.280		0.273	0.270	0.271	0.260		
AH	0.240	0.260		0.245	0.241	0.240	0.245		
AI	2.000	2.020		CANNOT MEASURED					
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: J.G
Date: 06/05/25

Audited by: E
Date: 06/06/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

